

Date: Wednesday, 22/10/2008 1:32:01 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	42823		
Estimate Number :	12967		
P.O. Number :		Part Number :	D36373
This Issue :	22/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3637 REV B
First Issue :	1/1	Project Number :	N/A
Previous Run :	33727	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>22/10/08 10:27</u>	Due Date :	04/11/2008
Comment :	Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC	Qty:	12 Um: Each

Additional Product

Job Number:



SCRAP

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
Comment: Qty.: 0.1407 sf(s)/Unit Total: 1.6884 sf(s) 2024-T3 .050 sheet Batch: <u>105646</u> <u>B8-10-23</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3637 Dwg Rev: <u>B</u> <u>B8-10-23</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B8-10-23</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B8-10-23</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>508/10/03</u> <u>(17)</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per Dwg D3637 <u>SB 08/11/04</u> <u>(11)</u> <u>SB 08/11/04</u> <u>(6)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-3 PAR #: N/A Fault Category: ENG - DESIGN NCR: Yes No DQA: 1 Date: 08.11.10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 08/11/11

NCR: <u>42823</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/07	12	All 17 parts scrap as have cracks from bending part were in production before the photo by no bend radius were to .160 has to be .188 part crack at the bend first time in production Q.C. process	10/5/11/02	Scrap Qty 17 Qty 11 Destroy and Replate New jig - no more crading	SB 08/11/05	5 8/11/05	10/5/11/02	8/10/07
			10/5/11/02	No Replate	SB 08/11/05	5 8/11/05	10/5/11/02	8/10/07
			10/5/11/02	New jig makes holes not line up. line up. Qty 6			10/5/11/02	08/11/07
			10/5/11/02	Scrap parts			10/5/11/02	08/11/07

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42823

Part Number: D36373

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



PTO

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE

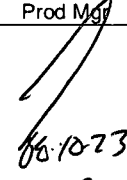

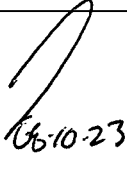



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-11-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	
	6.1	① drill holes as per drawing using AT8979 ② c/sink holes as per drawing				 06/10/23	 06/10/23	
	6.2	QC 5				 06/10/23	 06/10/23	

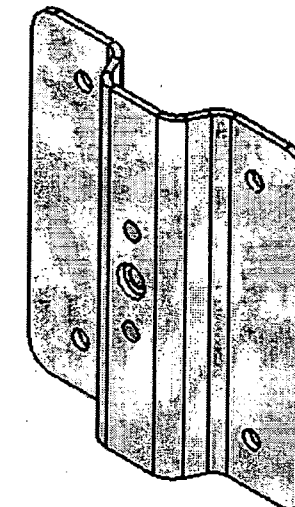
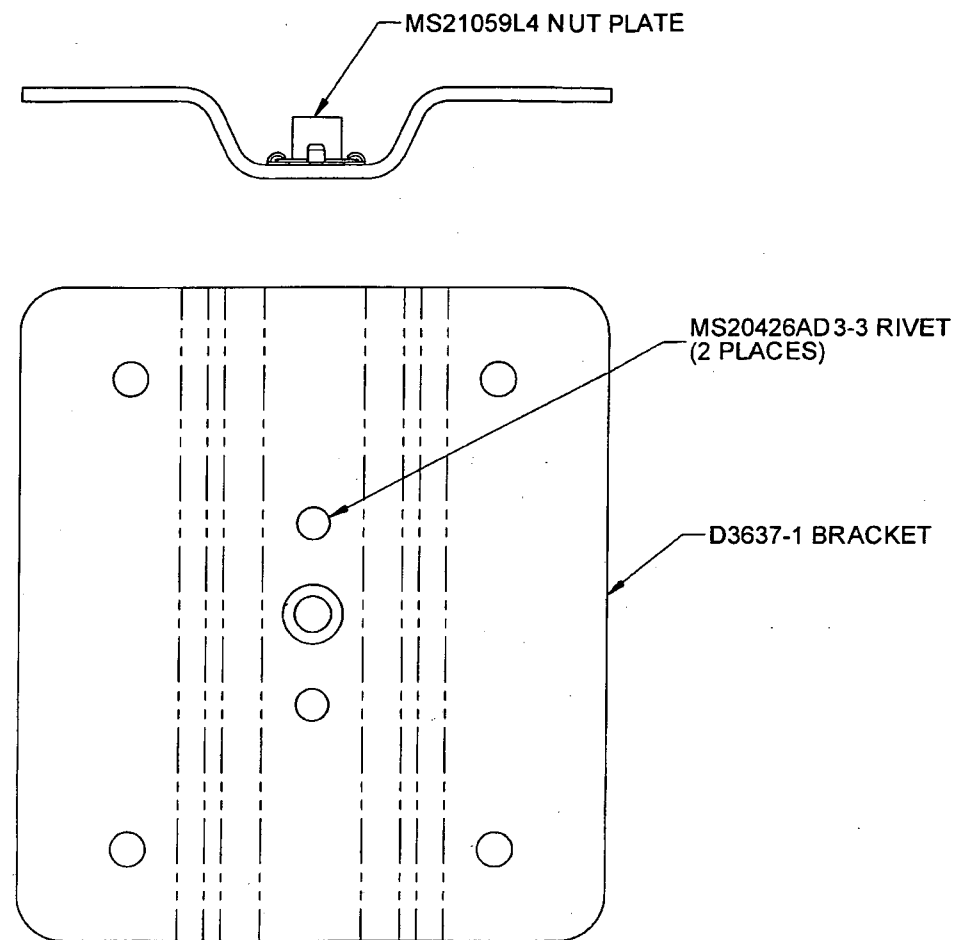
perm. change

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)**

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

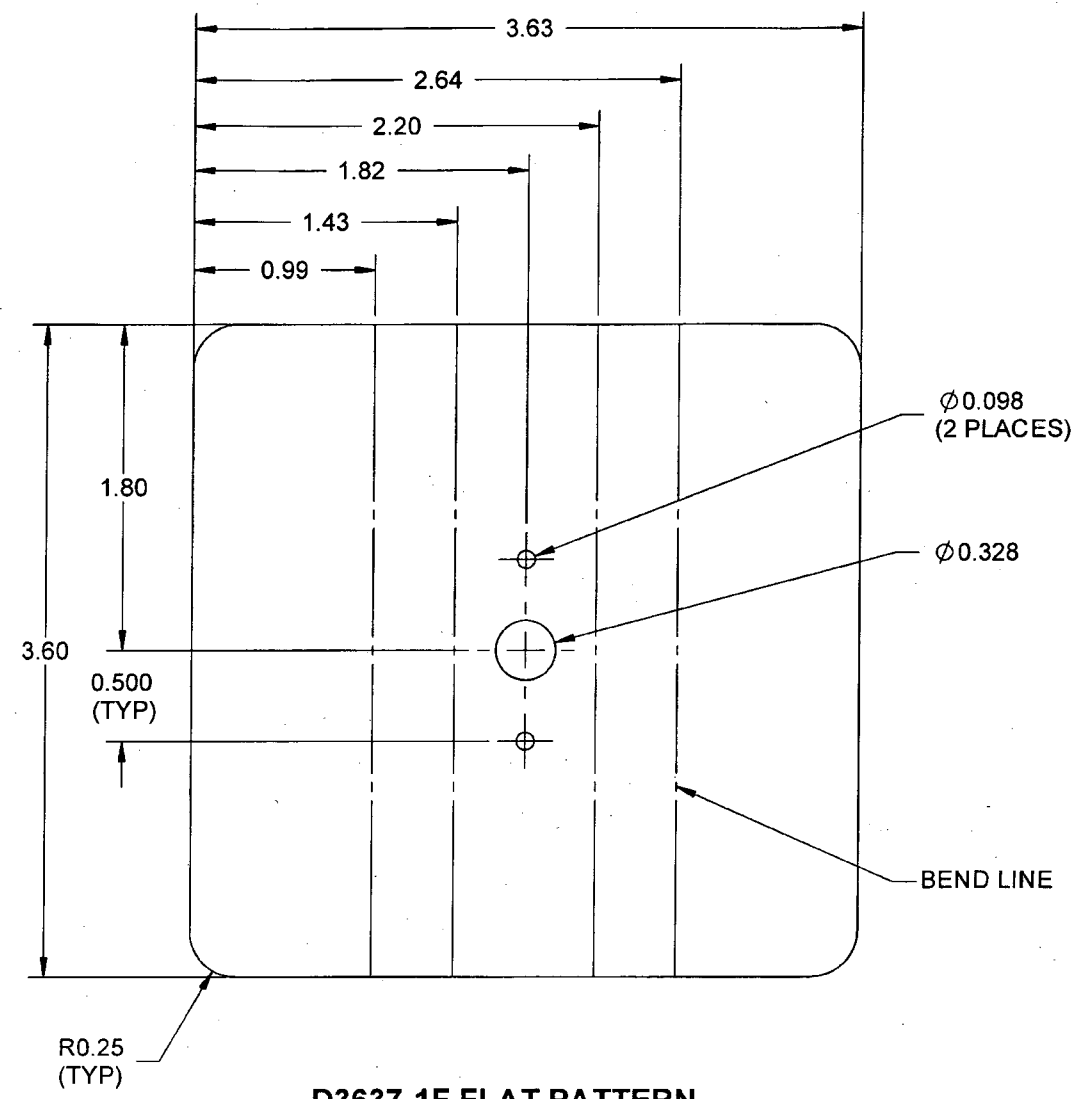
D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

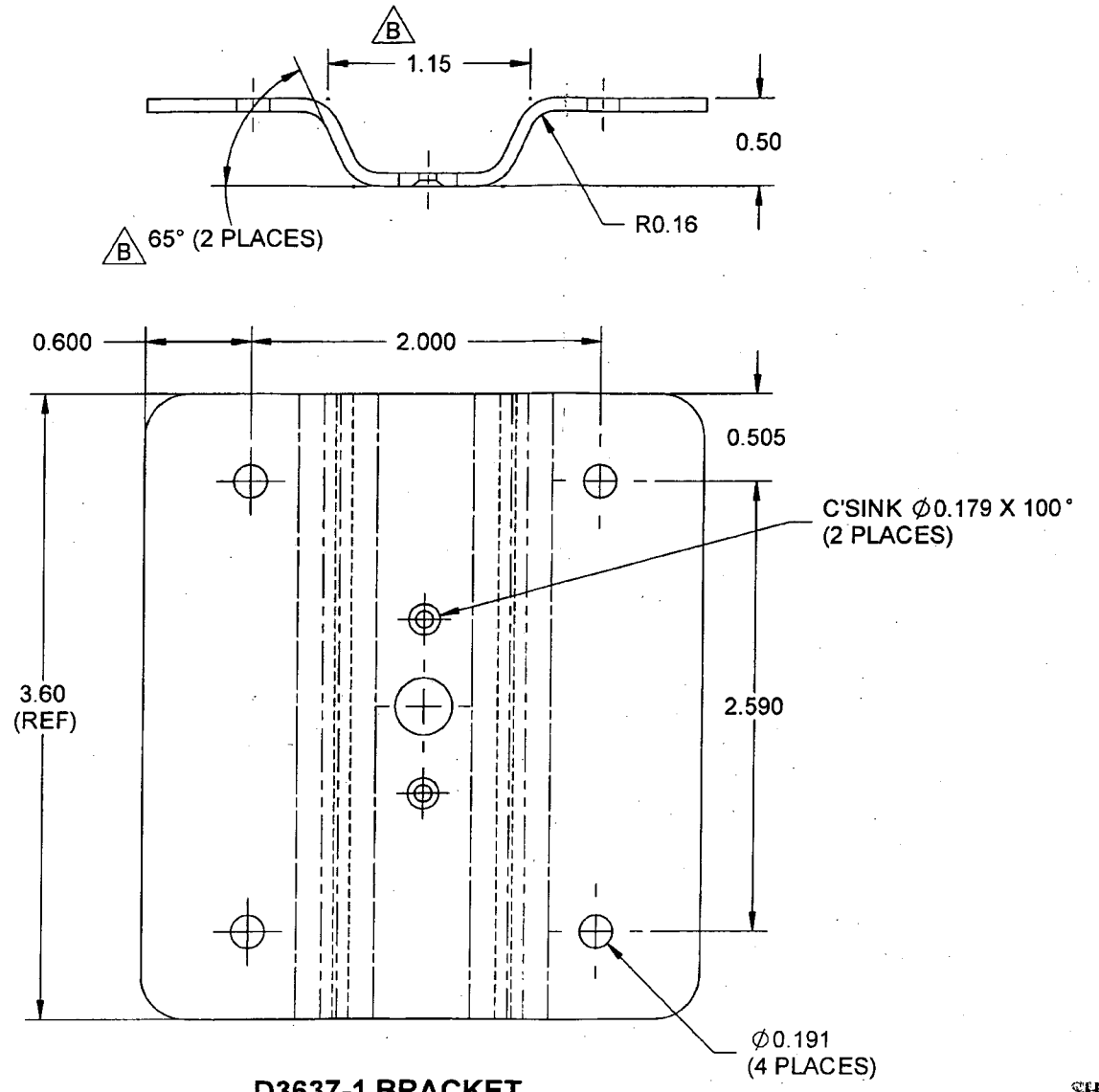
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WORK ORDER
NO 42823

B	FOR D3637-1; 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D3637	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BRACKET	1:1
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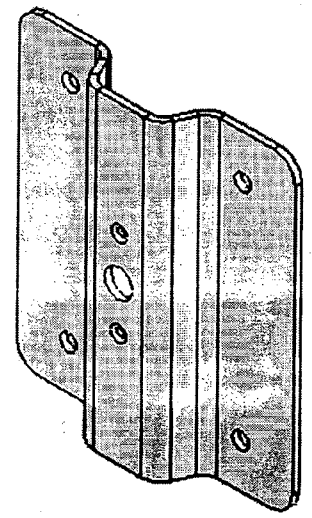
178979



D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)

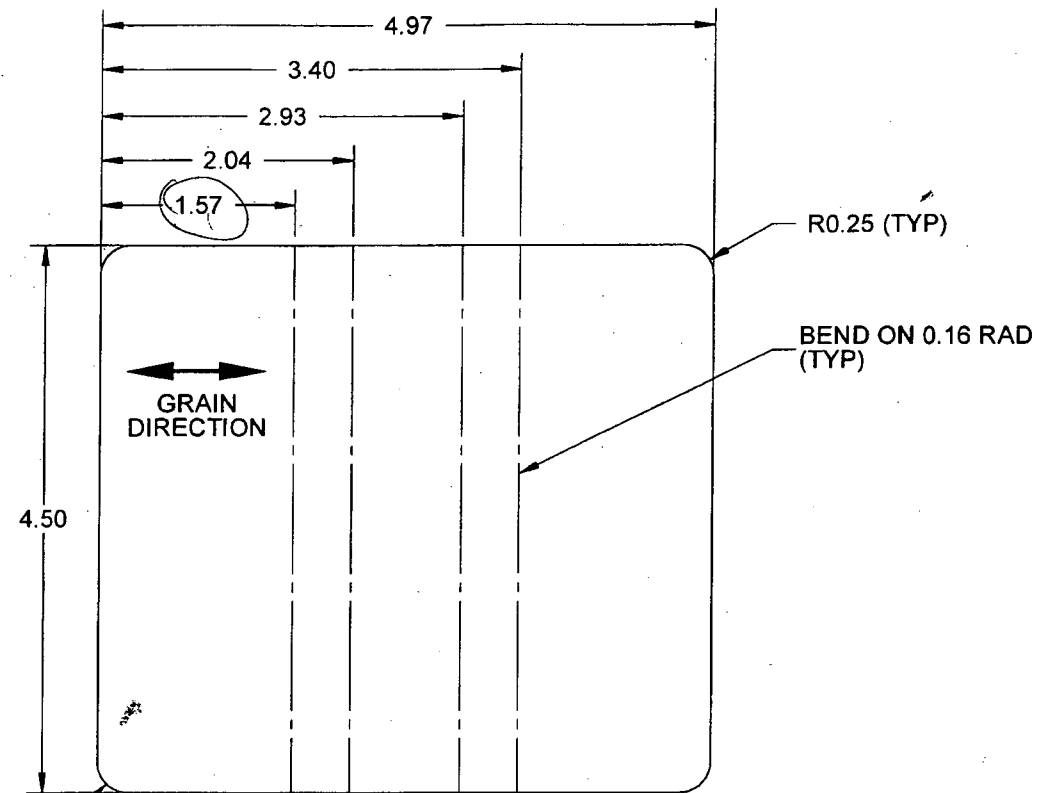


- D3637-1 NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

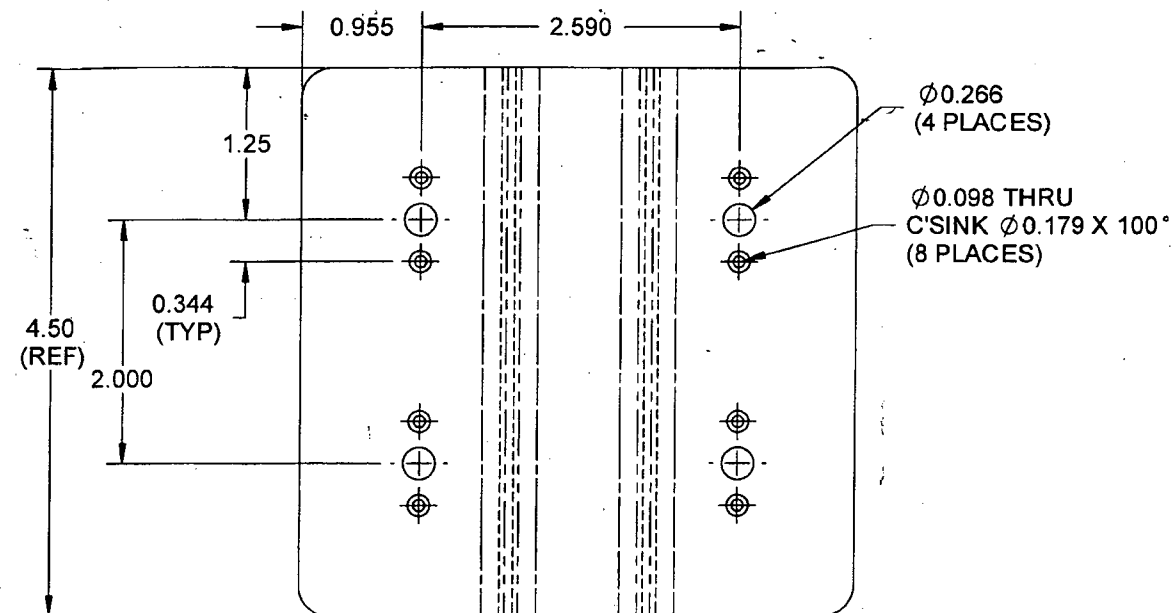
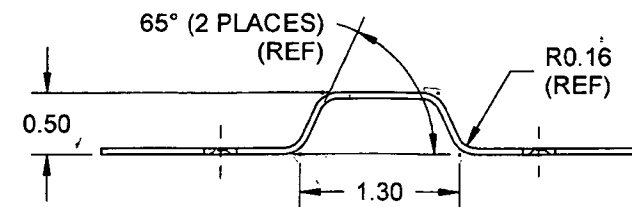
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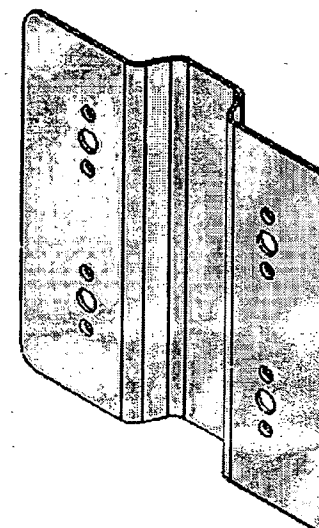
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D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

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